

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D206-540 REV. I

REF CANADIAN STC: SH94-5

REF FAA STC: SR00386NY

REF GERMAN STC: LBA RC 1124

THIS DART SERVICE INSTRUCTION PROVIDES GUIDELINES TO REPLACE THE EXISTING HINGE PLATES, INSTALL VIEWING/ACCESS PLATES AND ADDS ADDITIONAL STIFFENING TUBES TO THE BASKETS SQUARE TUBE STRUCTURE. THESE CHANGES MAY BE APPLIED TO D206-540-013 HELI-UTILITY-BASKETS AT CHG 005 AS CUSTOMERS REQUIRE.

REPLACEMENT PROCEDURE:

- 1) DISASSEMBLE BASKET RETAIN HARDWARE.
- 2) REPLACE HINGES IN ACCORDANCE WITH DSI 9448.
- 3) LOCATE THE D4317-1 VIEWING PLATE AND D4317-3 WIRING PLATE AND TRIM EXPANDED METAL AS SHOWN IN FIGURE 1 AND SECTIONS A-A & B-B. REMOVE PAINT ON EXPANDED METAL LOCALLY AND TIG WELD (TACK WELD) D4317-1 AND D4317-3 TO THE EXPANDED METAL, PER MIL-STD-2219/AMS-STD-2219 CLASS 'C' USING ER308L OR ER316L FILLER ROD.
- 4) LOCATE THE D4317-5 GPS PLATE AND TRIM EXPANDED METAL AS SHOWN IN SECTION C-C. REMOVE FINISH ON THE BASKET LID TUBULAR STRUCTURE AND EXPANDED METAL LOCALLY. TIG WELD (FILLET & TACK WELD) D4317-5 TO THE TUBULAR STRUCTURE AND EXPANDED METAL AS SHOWN IN FIGURE 1, PER MIL-STD-2219/AMS-STD-2219 CLASS 'C' USING ER308L OR ER316L FILLER ROD.
- 5) LOCATE D4317-011/-013 AS SHOWN IN SECTION C-C. REMOVE FINISH ON THE BASKET LID TUBES LOCALLY AND TIG WELD THE D4137-041/-043 COVER PANEL RETAINERS IN PLACE PER MIL-STD-2219/AMS-STD-2219 CLASS 'C' USING ER308L OR ER316L FILLER ROD.
- 6) LOCATE QTY (4) D4136-041 TUBE ASSEMBLIES AS SHOWN IN SECTION D-D. REMOVE FINISH ON THE BASKET BASE HOOPS LOCALLY AND TIG WELD THE D4136-041 TUBE ASSEMBLIES IN PLACE PER MIL-STD-2219/AMS-STD-2219 CLASS 'C' USING ER308L OR ER316L FILLER ROD.
- 7) TOUCH UP POWDER COAT OF AFFECTED AREAS ON BOTH LID AND BASE WITH WHITE POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 8) RE-ASSEMBLE BASKET. REPLACE ANY WORN HARDWARE AS NECESSARY.

PARTS LIST:

ITEM No.	QTY -041	PART NUMBER	DESCRIPTION
	X	DSI-9542-041	BASKET MODIFICATION
1	1	D206-540-013	BASKET ASSEMBLY
2	1	DSI-9448-011	HINGE UPGRADE KIT
3	4	D4316-041	TUBE ASSEMBLY
4	12	D4317-041	COVER PANEL RETAINER
5	4	D4317-043	COVER PANEL RETAINER
6	1	D4317-1	VIEWING PLATE
7	1	D4317-3	WIRING PLATE
8	1	D4317-5	GPS PLATE

PRELIMINARY A3
11.02.14 (AJS)

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: _____
D. SHEPHERD (DE # 02)

DATE: 11.02.08
CERT. NO.: SH94-5
ISSUE NO.: 4

PA3	PRELIMINARY, VIEWS INVERTED		AJS	11.02.04
REV.	DESCRIPTION		BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	AJS			
CHECKED		DRAWING NO.	REV. A	
MFG. APPR.		DSI 9542	SHEET 1 OF 4	
APPROVED		TITLE	SCALE	
DE APPR.		BASKET MODIFICATION	NTS	
DATE	11.02.04		COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

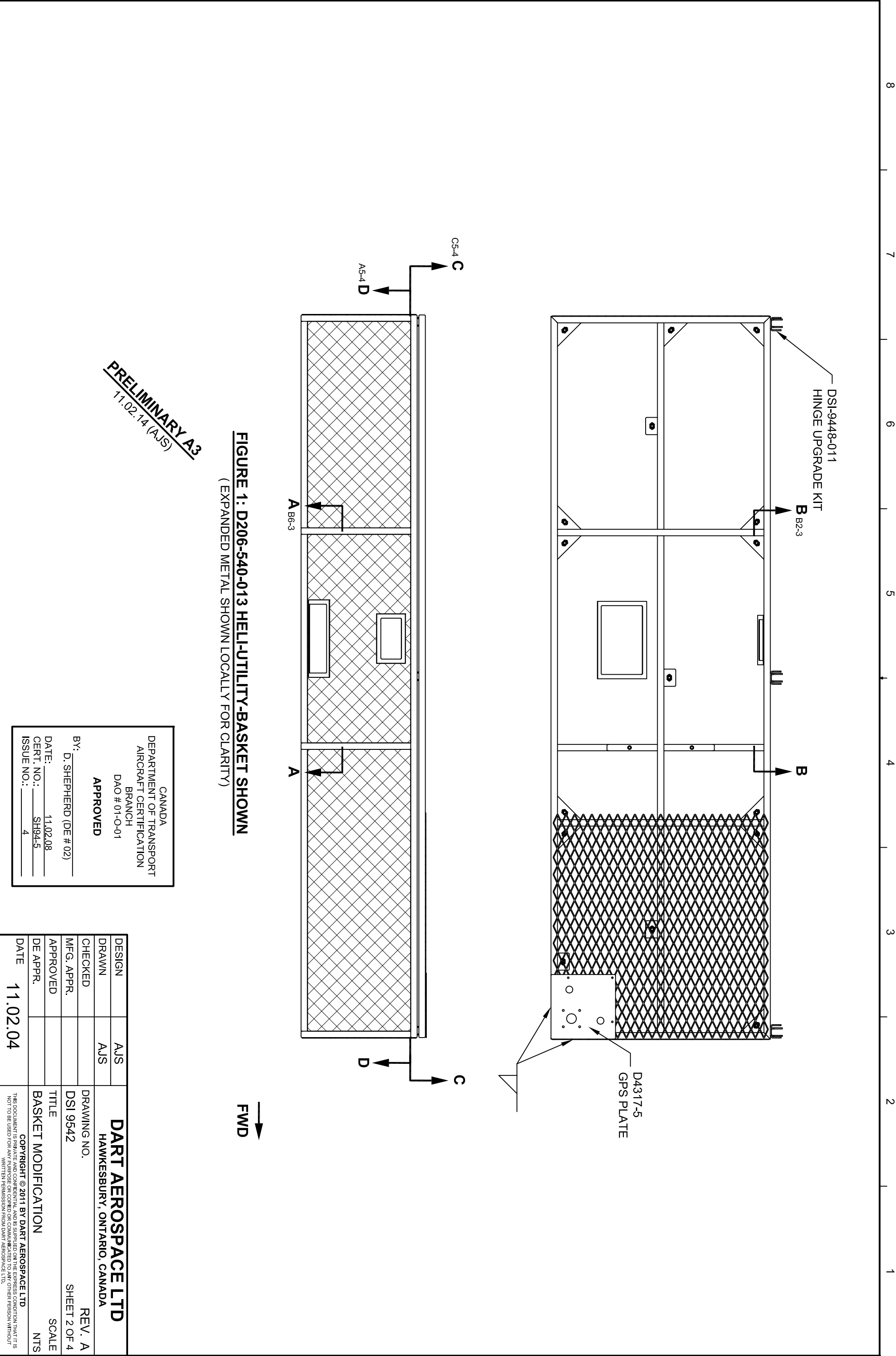


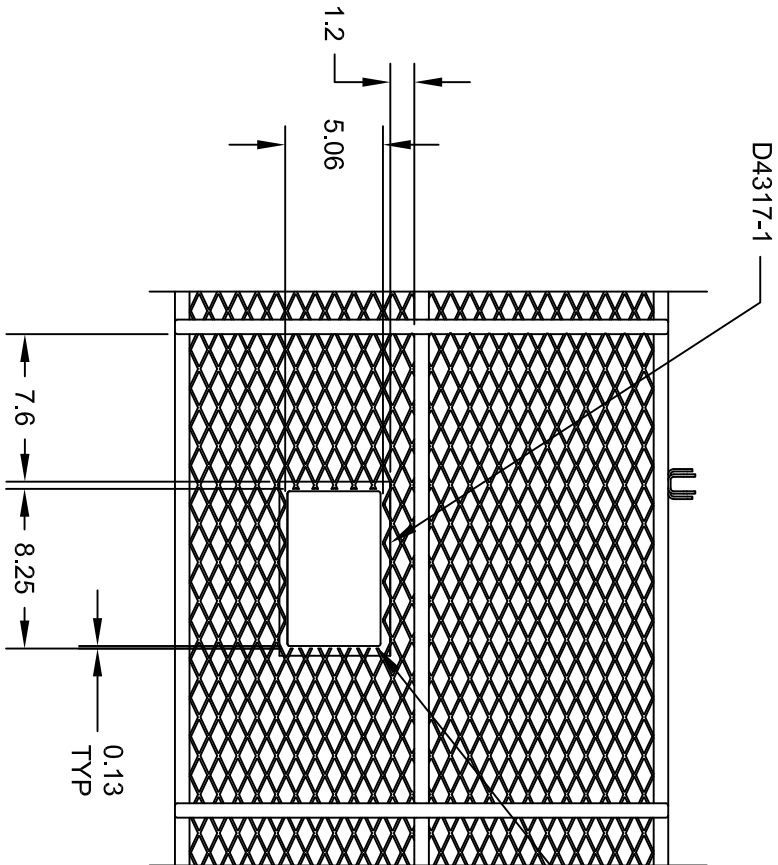
FIGURE 1: D206-540-013 HELI-UTILITY-BASKET SHOWN
(EXPANDED METAL SHOWN LOCALLY FOR CLARITY)

PRELIMINARY A3
11.02.14 (AJS)

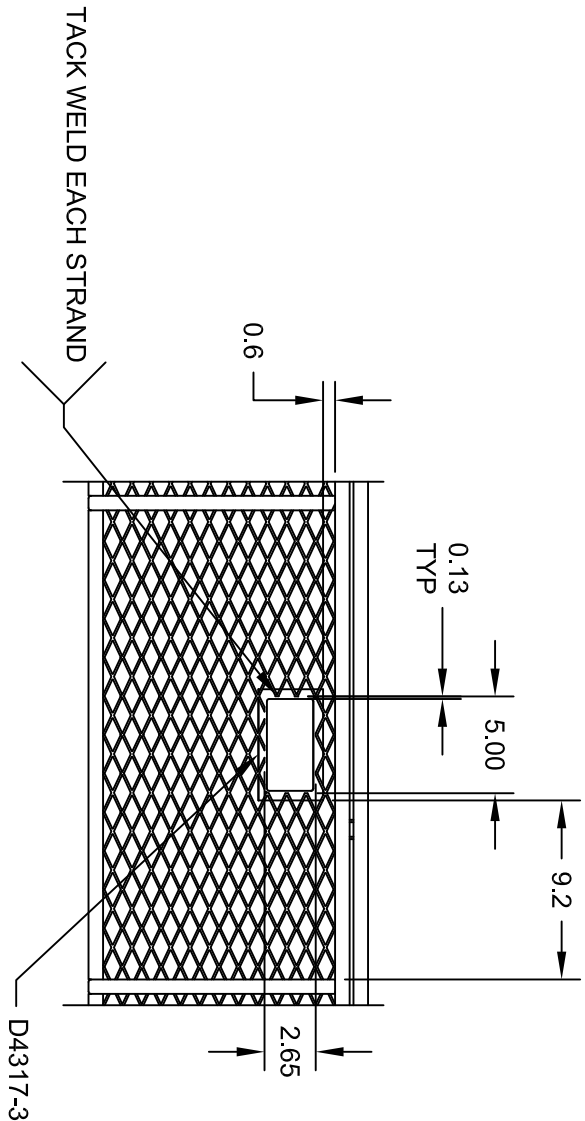
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DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. A SHEET 2 OF 4
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PRELIMINARY A3
11.02.14 (AJS)



SECTION A-A B5-2



SECTION B-B D5-2

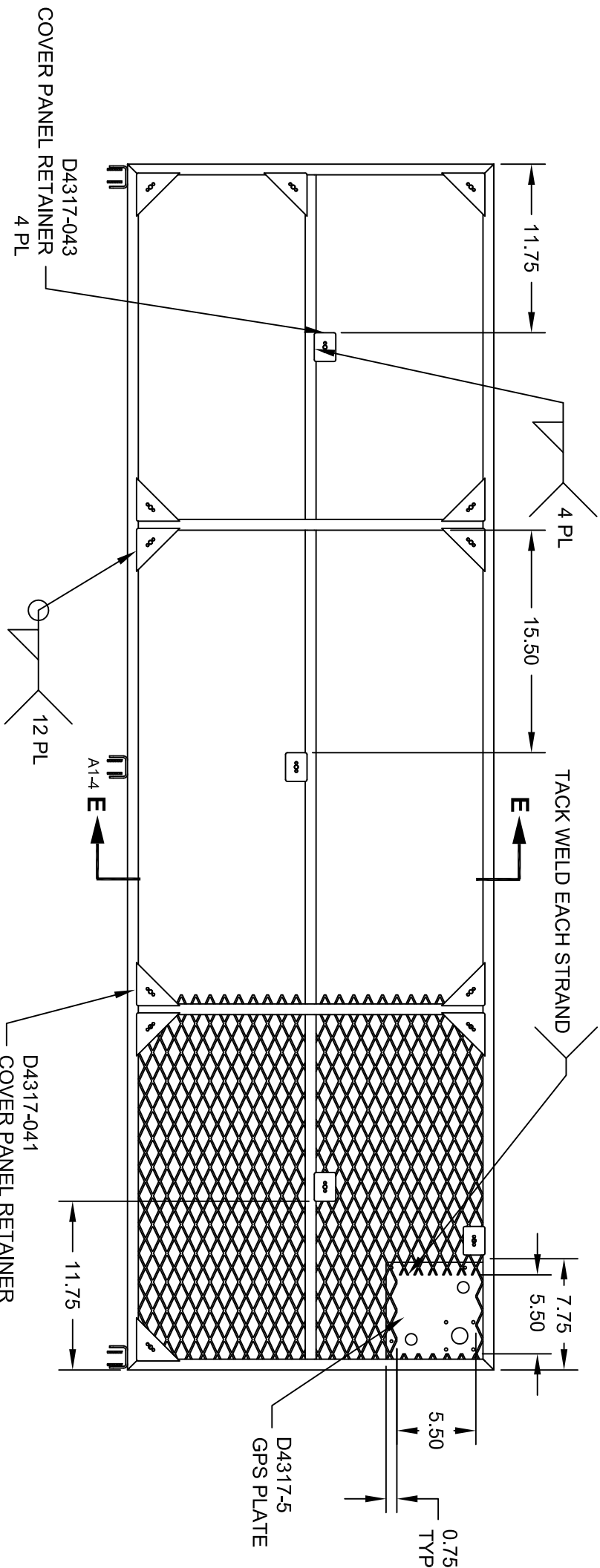
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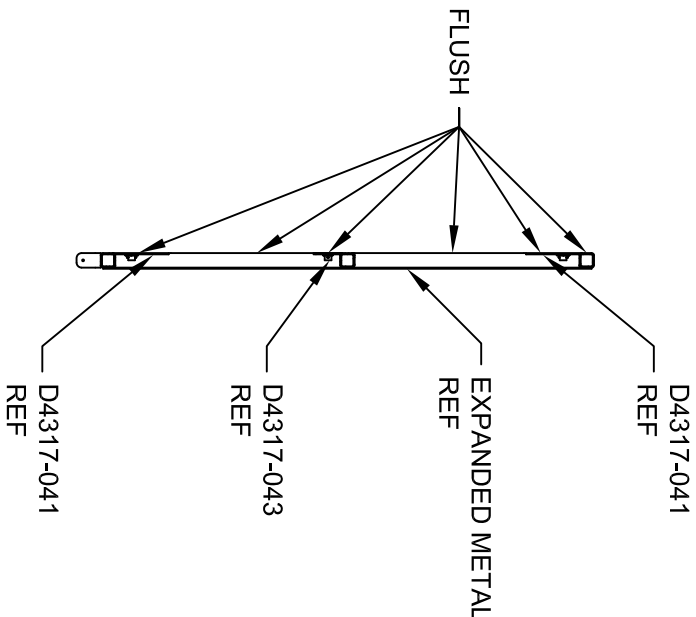
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DATE	11.02.04	

DRAWING NO.	REV. A
DSI 9542	SHEET 3 OF 4
TITLE	SCALE
BASKET MODIFICATION	NTS

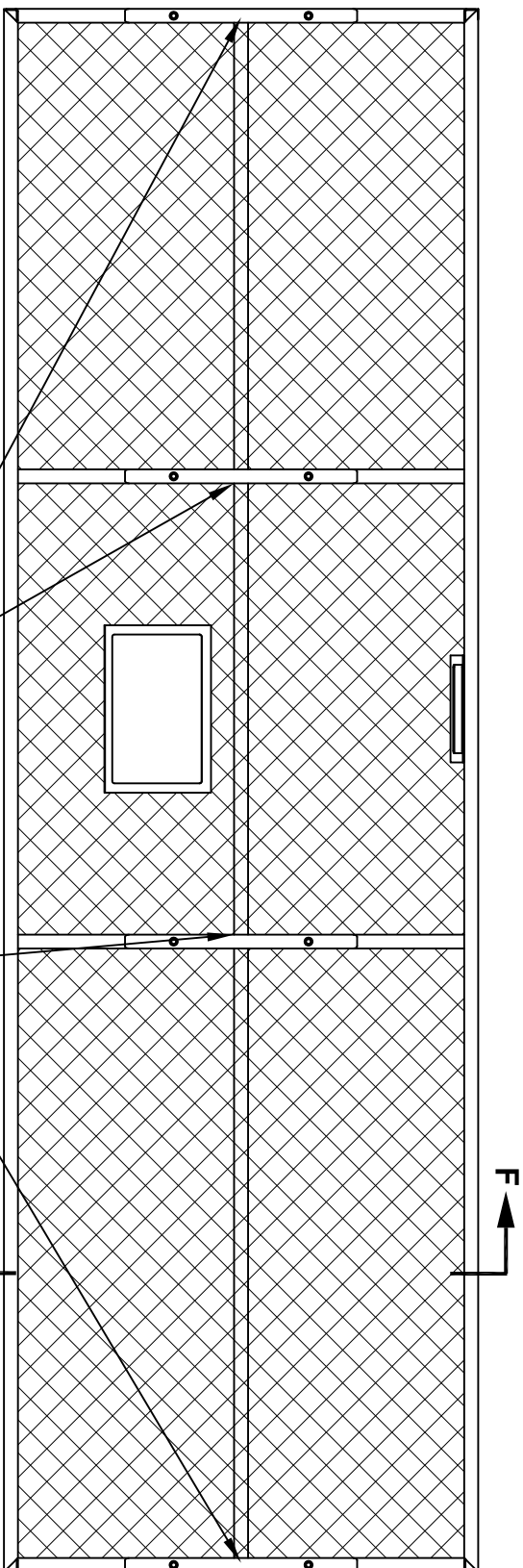
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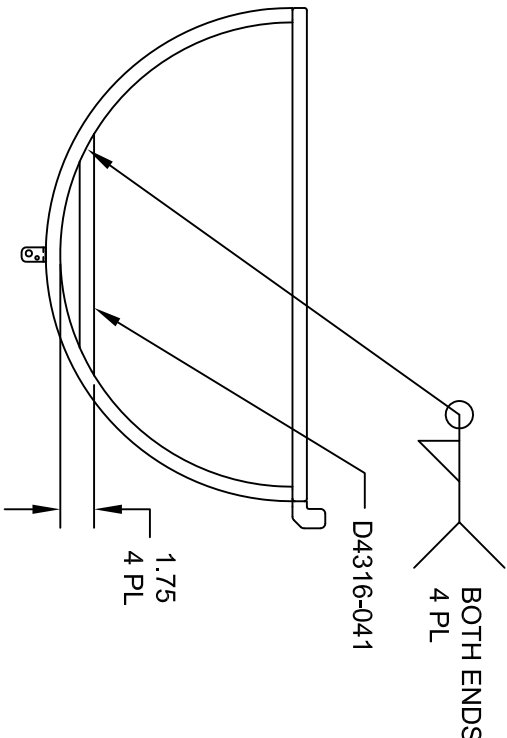
SECTION C-C C7-4
(VIEW LOOKING UP EXPANDED METAL SHOWN LOCALLY FOR CLARITY)



SECTION E-E C5-4



SECTION D-D B7-4



SECTION F-F A5-4

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		REV. A	SHEET 4 OF 4
		SCALE	NTS